

R ASAP A

Dart Aerospace Ltd.

Date: Tuesday, 15/07/2008 9:15:17 AM  
User: Julie Lecocq

# Process Sheet

Customer : CU-DAR001, Dart Helicopters Services

Drawing Name : FITTING

Job Number : 40486-1

Estimate Number : 10844

P.O. Number :

Part Number : D2249041

This Issue : 15/07/2008 S.O. No. :

Drawing Number : D2249 REV. E

Prsht Rev. : NC

Project Number : N/A

First Issue : / / Type : SMALL / MED FAB

Drawing Revision : E

Previous Run : 34671

Material :

Due Date : 22/07/2008

Qty: 10 Um: Each

Written By :

Checked & Approved By : JUD 08.15.08

Comment : Est: D 05.02.04 Added Step 9 KJ/RF

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D22491

Lug

15/07/08



Comment: Qty.: 210.0000 Each(s)/Unit Total: 210.0000 Each(s)

Lug

B 9405 ✓

EL 8-7-28

2.0

D22493

Base Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Base Plate

B 11016 → 2 ✓ B 22498 → 3 ✓

Cpl 08-07-28

3.0

D22495

Gusset



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Gusset

B 31609 → 6 ✓ B 31485 → 4 ✓

Cpl 08-07-28

4.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
Weld as per Dwg D2249 and QSI 004

EL / Cpl 06-07-28 ⑤

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-07-28 ⑤

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/28 (X)





# Process Sheet

CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Number: 40486

Part Number: D2249041

Number:



Seq. #:

Machine Or Operation:

Description :

7.0

POWDER COATING

POWDER COATING



M108523



(5x)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:00  
400 °F  
2:30

m.f 08/07/28

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(5)

Comment: INSPECT POWDER COAT

Fd 08/07/28

9.0

PACKAGING 1

PACKAGING RESOURCE #1



(5x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 198A

8/7/29

sf

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/30

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-29

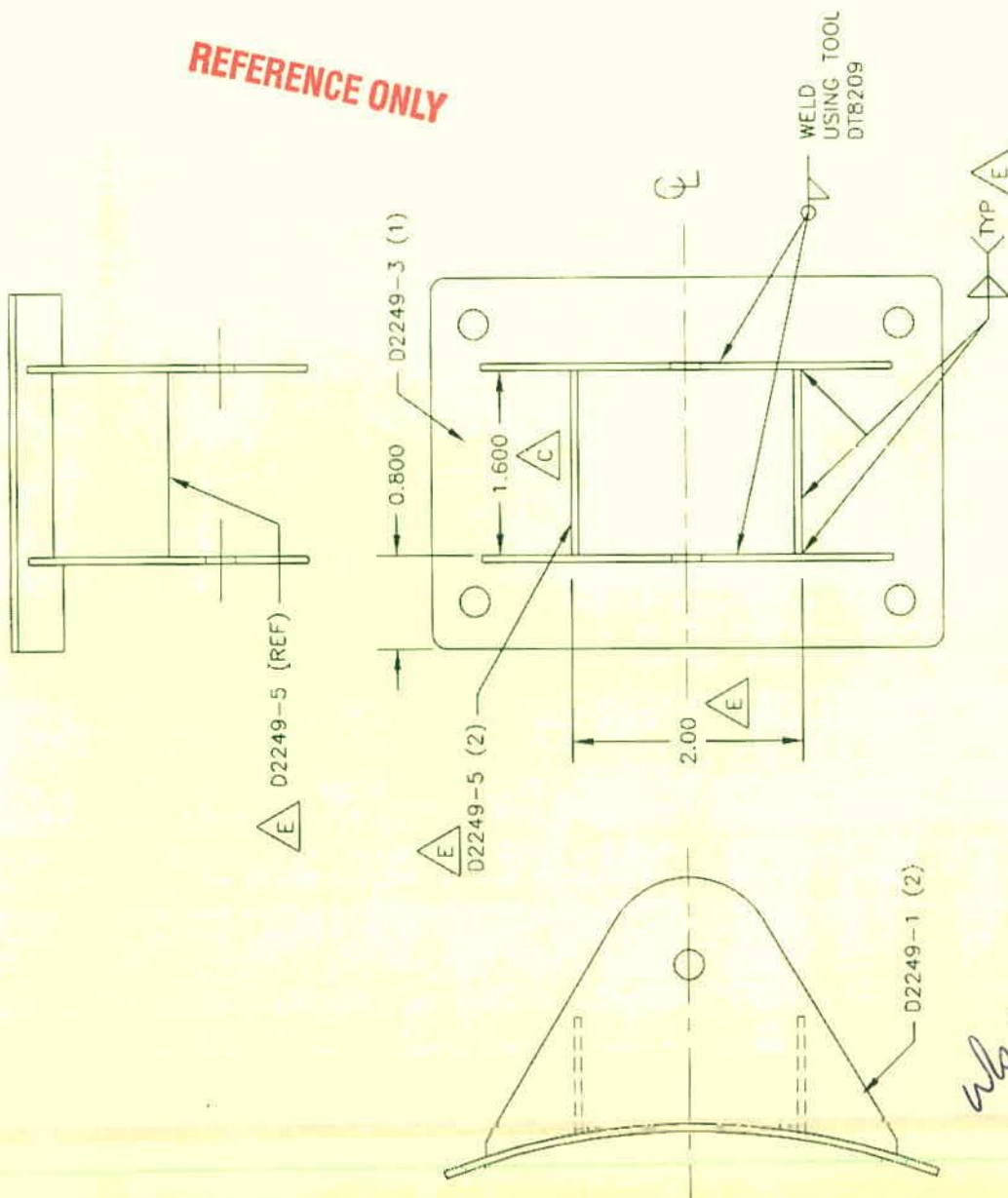




**DART**RELEASED  
90 10 17 KE

DESIGN KE	DRAWN BY KF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED H	DRAWING NO. D2249	REV. E SHEET 1 OF 4
DATE 99.09.20		TITLE FITTING	SCALE NTS
A	94.06.20	NEW ISSUE	
B	95.11.30	DIMENSION CHANGE	
C	95.12.14	DIMENSION CHANGE	
D	98.04.30	Ø0.261 WAS Ø0.257 (TSR A179) REMOVED DUPLICATE DIMENSIONS	
E	99.09.20	ADDED GUSSET	

REFERENCE ONLY



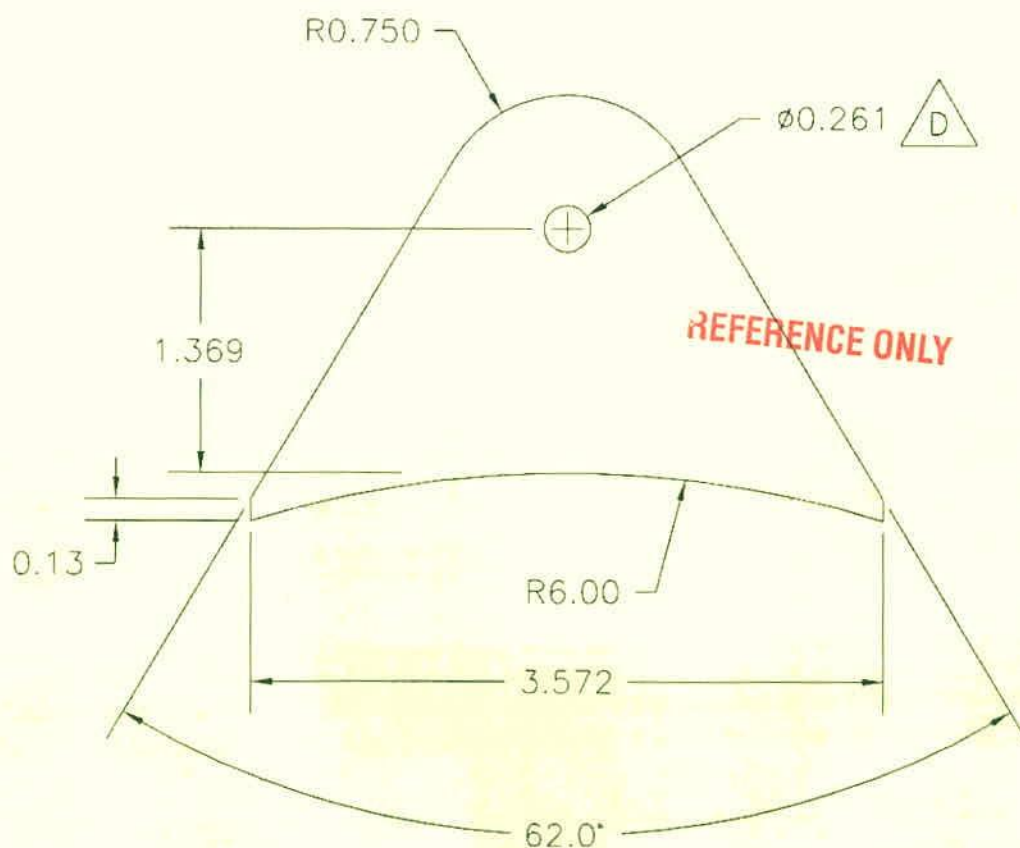
MATERIAL: AISI 304/316 SS, 0.063 THICK  
WELD PER DART QSI 004  
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
ALL DIMENSIONS ARE IN INCHES  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED

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CHECKED <i>KE</i>	APPROVED <i>H</i>	DRAWING NO. D2249	REV. E SHEET 2 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED  
OCT 1 1999



D2249-1 LUG

w/040486

MATERIAL: AISI 304/316 SS 0.063 THICK  
ALL DIMENSIONS ARE IN INCHES  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



REFERENCE ONLY

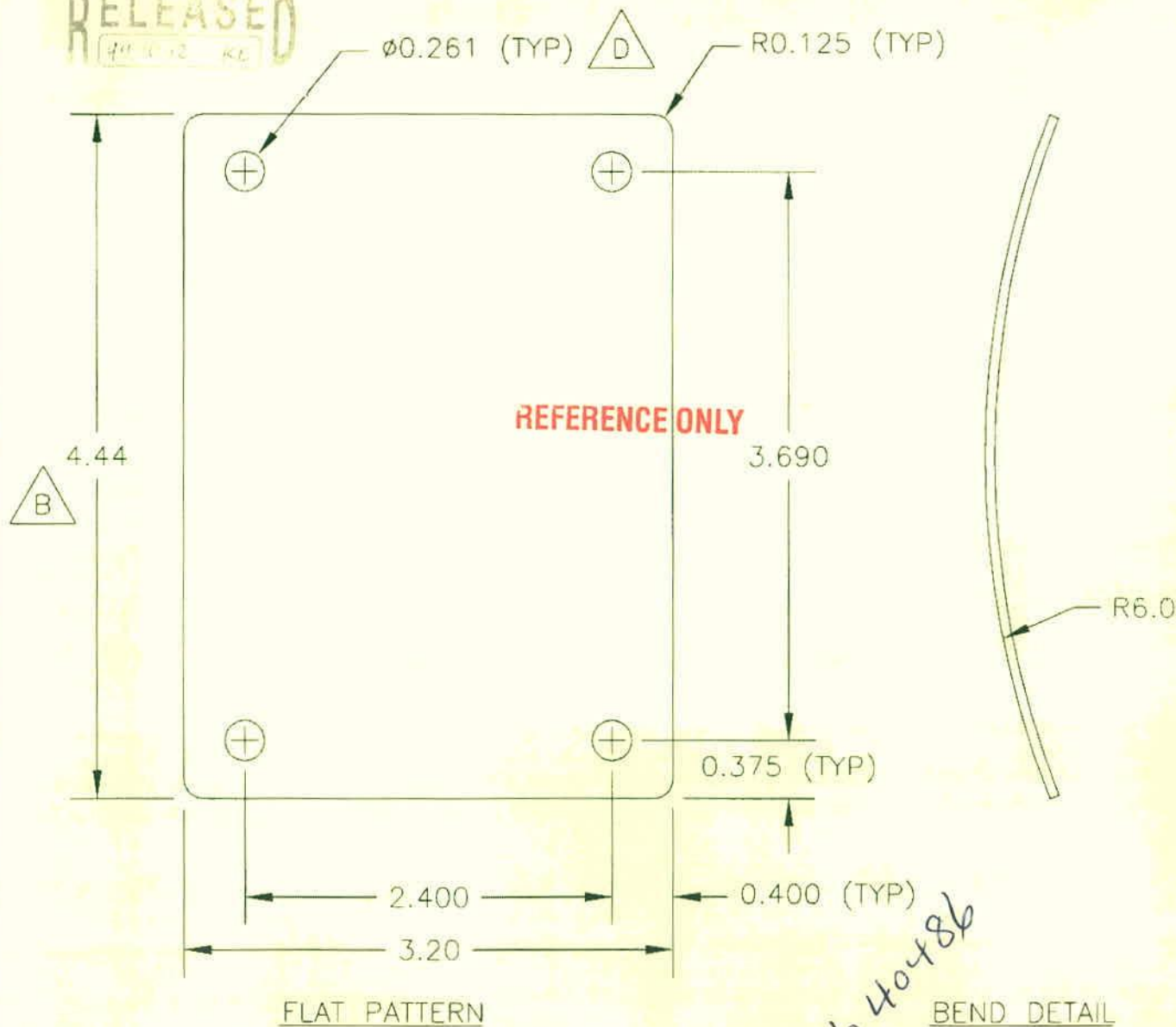


**DART**



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>PH</i>	DRAWING NO. D2249	REV. E SHEET 3 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED  
40486 KE



D2249-3 BASE PLATE

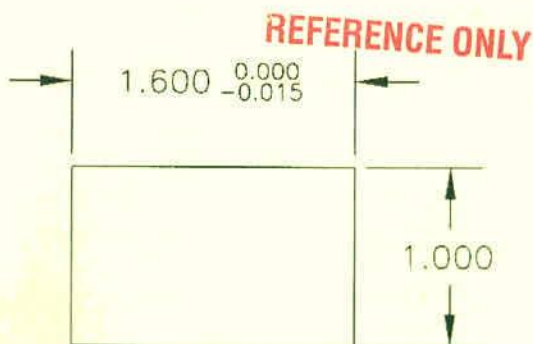
MATERIAL: AISI 304/316 SS 0.063 THICK  
ALL DIMENSIONS ARE IN INCHES  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED





DESIGN BY <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>TH</i>	DRAWING NO D2249	REV. E SHEET 4 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED  
1999 09 20 14



D2249-5 GUSSET

*Wb 40486*

MATERIAL: AISI 304/316 SS 0.063 THICK  
ALL DIMENSIONS ARE IN INCHES  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



